AMENDMENTS TO THE CLAIMS

1. Claims 1-19 (Canceled)

20. (Currently Amended) A method for forming a golf club shaft around a mandrel having a length along a longitudinal axis, the steps comprising:

forming a first reinforcement layer from a first fiber material, said first fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said first reinforcement layer;

forming a first angled layer by bonding second and third fiber materials, such that the fibers of said second material form a first angle with the fibers of said third material, said second and third materials having fibers aligned along a single direction and said second and said third fibers only extending along an entire length of said first angled layer;

forming a first straight layer from a fourth fiber material, said fourth fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said first straight layer;

forming a second angled layer from fifth and sixth fiber material, said fifth and sixth materials having fibers aligned along a single direction and said fifth and said sixth fibers only extending along an entire length of said second angled layer;

bonding said fifth and sixth fiber materials together to form said second angled layer, such that said fibers of said fifth and sixth material form a second angle in the range of from 70-150 degrees and said second angled layer has a thickness in the range of from 0.04 to 0.1 mm;

forming a second straight layer from a seventh fiber material, said seventh fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said second straight layer;

forming a second reinforcement layer from an eighth fiber material, said fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said second reinforcement layer;

wrapping said first reinforcement layer around said mandrel such that said fibers of said first reinforcement layer are aligned 90 degrees with respect to said longitudinal axis;

wrapping said first angled layer around said first reinforcement layer such that said first angle of said fiber material of said first angled layer is bisected by said longitudinal axis;

wrapping said first straight layer around said first angled layer such that said fibers of said first straight layer are aligned with said longitudinal axis;

wrapping said second angled layer around said first straight layer such that said second angle of said fiber material of said second angled layer is bisected by said longitudinal axis;

wrapping said second straight layer around said second angled layer such that said fibers of said second straight layer are aligned with said longitudinal axis;

wrapping second reinforcement layer around said second straight layer to form a layered wrap, such that said fibers of said second reinforcement layer are aligned with said longitudinal axis;

curing said layered wrap in an oven to form a cured shaft;

removing said mandrel from said cured shaft; and

trimming ends said cured shaft to produce said golf club shaft having a weight of 30 to 40 grams.

21. (Currently Amended) A method for forming a golf club shaft around a mandrel having a length along a longitudinal axis, the steps consisting of:

forming a first reinforcement layer from a first fiber material, said first fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said first reinforcement layer;

forming a first angled layer by bonding second and third fiber materials, such that the fibers of said second material form a first angle with the fibers of said third material, said second and third materials having fibers aligned along a single direction and said second and said third fibers only extending along an entire length of said first angled layer;

forming a first straight layer from a fourth fiber material, said fourth fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said first straight layer;

forming a second angled layer from fifth and sixth fiber material, said fifth and sixth materials having fibers aligned along a single direction and said fifth and said sixth fibers only extending along an entire length of said second angled layer;

bonding said fifth and sixth fiber materials together to form said second angled layer, such that said fibers of said fifth and sixth material form a second angle in the range of from 70-150 degrees and said second angled layer has a thickness in the range of from 0.04 to 0.1 mm;

forming a second straight layer from a seventh fiber material, said seventh fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said second straight layer;

forming a second reinforcement layer from an eighth fiber material, said fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said second reinforcement layer;

wrapping said first reinforcement layer around said mandrel such that said fibers of said first reinforcement layer are aligned 90 degrees with respect to said longitudinal axis;

wrapping said first angled layer around said first reinforcement layer such that said first angle of said fiber material of said first angled layer is bisected by said longitudinal axis;

wrapping said first straight layer around said first angled layer such that said fibers of said first straight layer are aligned with said longitudinal axis;

wrapping said second angled layer around said first straight layer such that said second angle of said fiber material of said second angled layer is bisected by said longitudinal axis;

wrapping said second straight layer around said second angled layer such that said fibers of said second straight layer are aligned with said longitudinal axis;

wrapping second reinforcement layer around said second straight layer to form a layered wrap, such that said fibers of said second reinforcement layer are aligned with said longitudinal axis;

curing said layered wrap in an oven to form a cured shaft;

removing said mandrel from said cured shaft; and

trimming ends said cured shaft to produce said golf club shaft.

22. (Currently Amended) A method for forming a golf club shaft around a mandrel having a length along a longitudinal axis, the steps comprising:

forming a first reinforcement layer from a first fiber material, said first fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said first reinforcement layer;

forming a first angled layer by bonding second and third fiber materials, such that the fibers of said second material form a first angle with the fibers of said third material, said second and third materials having fibers aligned along a single direction and said second and said third fibers only extending along an entire length of said first angled layer;

forming a first straight layer from a fourth fiber material, said fourth fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said first straight layer;

forming a second angled layer from fifth and sixth fiber material, said fifth and sixth materials having fibers aligned along a single direction and said fifth and said sixth fibers only extending along an entire length of said second angled layer;

bonding said fifth and sixth fiber materials together to form said second angled layer, such that said fibers of said fifth and sixth material form a second angle in the range of from 70-150 degrees and said second angled layer has a thickness in the range of from 0.04 to 0.1 mm;

forming a second straight layer from a seventh fiber material, said seventh fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said second straight layer;

forming a second reinforcement layer from an eighth fiber material, said fiber material having fibers aligned along a single direction and said fibers only extending along an entire length of said second reinforcement layer;

wrapping said first reinforcement layer around said mandrel such that said fibers of said first reinforcement layer are aligned 90 degrees with respect to said longitudinal axis;

wrapping said first angled layer directly around said first reinforcement layer such that said first angle of said fiber material of said first angled layer is bisected by said longitudinal axis;

wrapping said first straight layer directly around said first angled layer such that said fibers of said first straight layer are aligned with said longitudinal axis;

wrapping said second angled layer directly around said first straight layer such that said second angle of said fiber material of said second angled layer is bisected by said longitudinal axis;

wrapping said second straight layer directly around said second angled layer such that said fibers of said second straight layer are aligned with said longitudinal axis;

wrapping second reinforcement layer directly around said second straight layer to form a layered wrap, such that said fibers of said second reinforcement layer are aligned with said longitudinal axis;

curing said layered wrap in an oven to form a cured shaft;

removing said mandrel from said cured shaft; and

trimming ends said cured shaft to produce said golf club shaft.